

Date: Tuesday, 26/05/2009 12:34:02 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 212 BASKET BASE ASS'Y LH
Job Number : 48209B	
Estimate Number : 11542	
P.O. Number :	Part Number : D3053041
This Issue : 26/05/2009 S.O. No. :	Drawing Number : D3053 REVB
Prsht Rev. : NC	Project Number :
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 48202B	Material :
Written By :	Due Date : 01/06/2009 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Est. C 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K J/RF Est Rev:D 08-08-29 revB as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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End Bar Scrap = 1.5 sf



Comment: Qty.: 45.5000 f(s)/Unit Total : 45.5000 f(s)
 304 SQ Tube.75x.75x.065W

1-Cut Rib from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing.

Batch: 0111432

2-Drill holes in D3053-3 as per dwg D3053

SAD 09-05-27

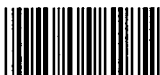
2.0	D31661	Basket Hoop
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Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Basket Hoop
 Cut
 Qty. 5 D3166-1
 Batch: 347956

Cpl 07-05-26

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut 5 D2235-3 FROM D3166-1 using DT8365

2-Drill holes in three D2235-3 ribs as per dwg D3053 using DT8995

Cpl 09-05-26

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 48209B

Part Number: D3053041

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 4.0 D23273 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Pick:

Qty Part Number Description Batch

2 D2327-3 Bushing B44365

PD 09.05.27

✓ 5.0 D22323 Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Pick:

Qty Part Number Description Batch

2 D2232-3 Hinge plate B46822

PD 09.05.27

✓ 6.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket 46086

PD 09.05.28

✓ 7.0 M304EX07516F Expanded Metal Flat SS



Comment: Qty.: 50.4000 sf(s)/Unit Total : 50.4000 sf(s)

Expanded Metal Flat Stai

Pick:

Qty Part Number Description Batch

48sq.ft M304EX0.75-16F Expanded Metal 110992 (8) 111173 (10) 11630 (32)

SAD09-05-27 ①

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove all markings from material 46086

2-Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required

****Ensure ribs are positionned for LH****

PD 09.05.26

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Job Number:



Seq. #: Machine Or Operation: Description :

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Pl 09-05-28

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

09/05/28 @

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

1st

OVEN TEMPERATURE: _____

FINISH TIME: _____

7:05am

400°F

7:30am

2ND

7:50am START

400°F Temp

8:20am Finish

09-05-29 (X)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/05/29 (1)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

48209 9/5/29

54

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/29

Job Completion



mf 09-05-29

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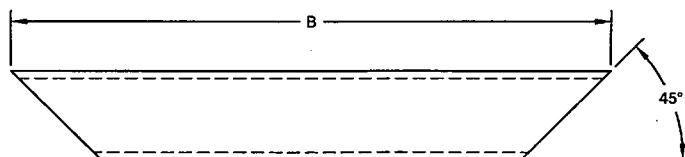
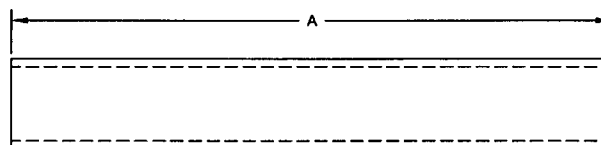
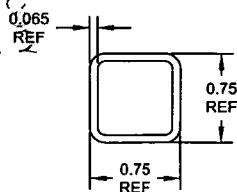
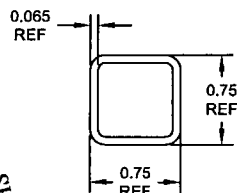
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NOTE: Date & initial all entries

PARTS LIST FOR D3053-041/D3053-042 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3053-1	2	—	96.00	RIB
D3053-3	2	—	25.50	RIB
D3053-5	6	23.73	—	RIB
D3053-7	3	25.31	—	RIB
D3053-9	3	19.48	N/A	RIB
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-3	5	N/A	N/A	RIB



NO. 1720
WORK ORDER
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
0.065 REF



NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 10) WELD PER DART QSI 004

RELEASED
08-08-2011

B	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.02
A	NEW ISSUE	RF	01.11.01
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3053	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
DATE	08.07.02	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

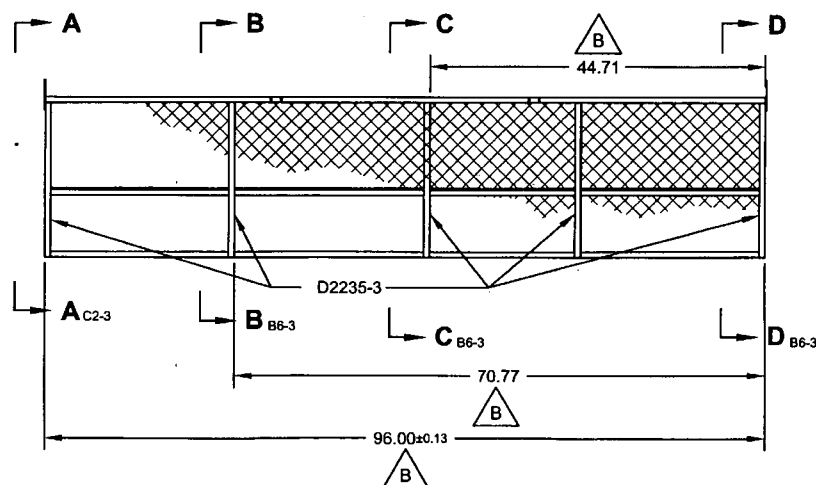
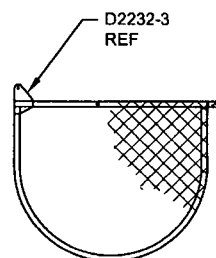
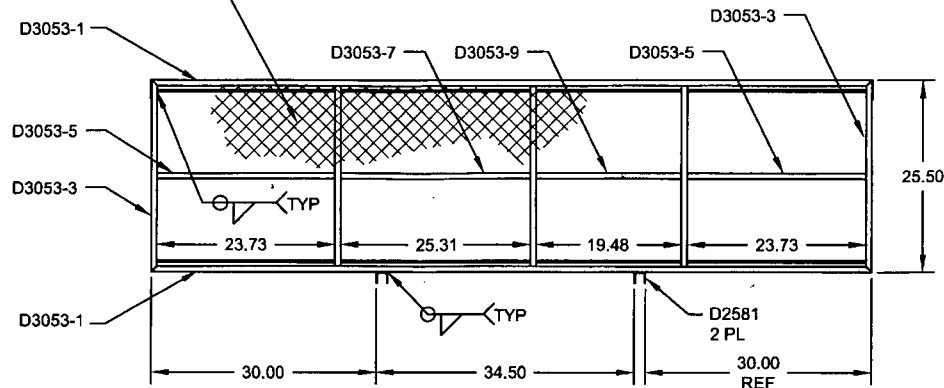
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SKIN INSIDE SURFACE OF
BASKET WITH MESH. TACK
WELD EACH END OF STRAND
TO FRAME



**D3053-042 BASKET BASE ASSEMBLY SHOWN
(D3053-041 BASKET BASE ASSEMBLY OPPOSITE)**

RELEASED

NO. 4282017
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3053	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
DATE	08.07.02	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

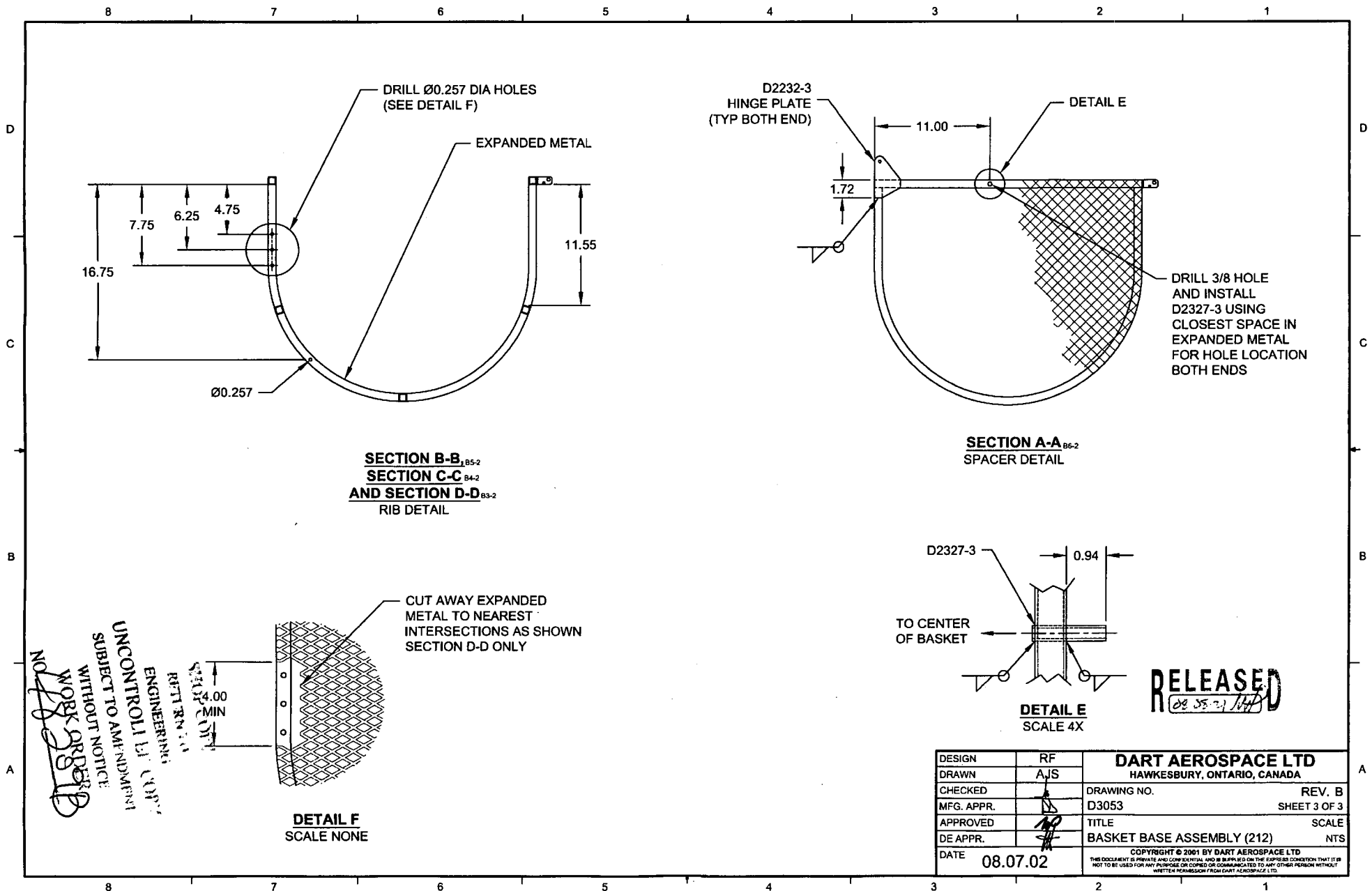
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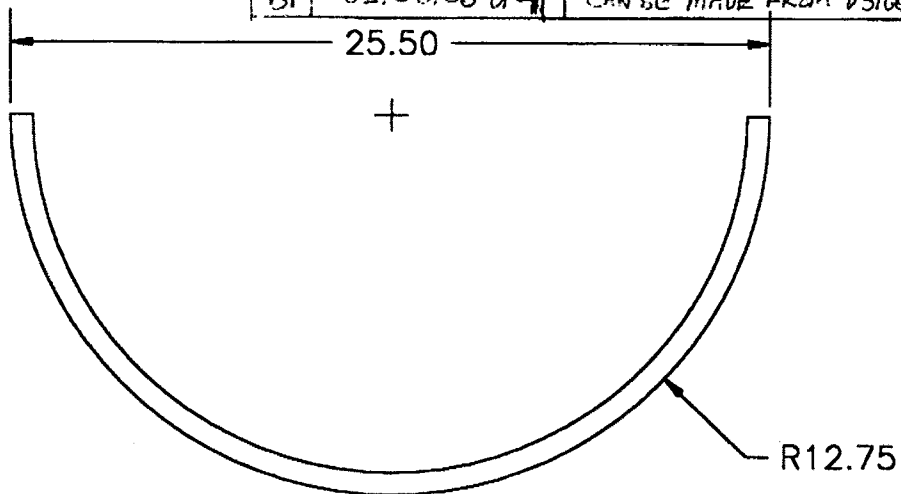
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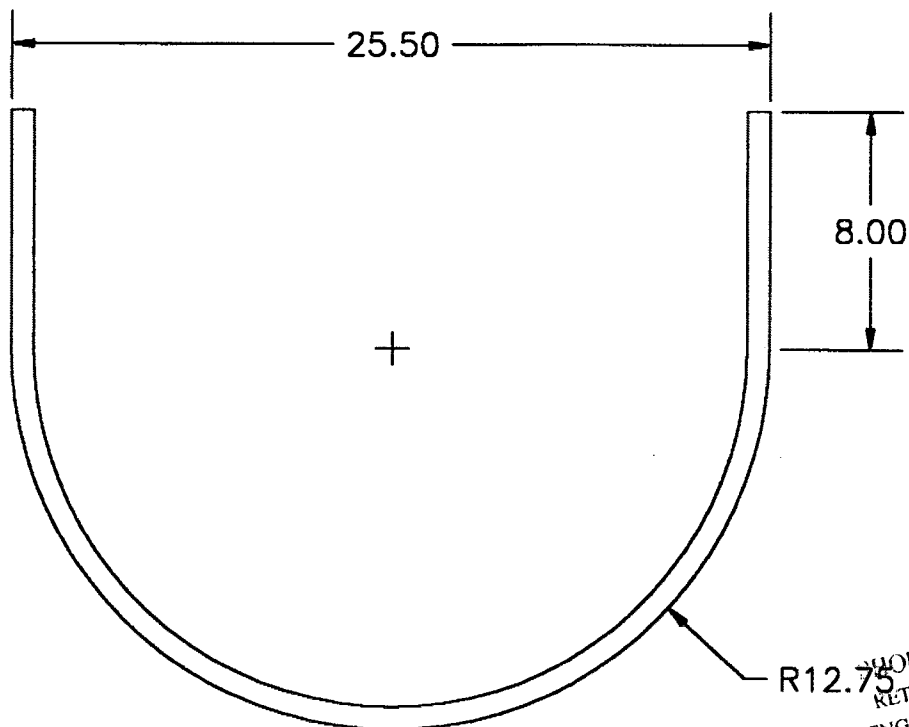
DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2235	REV. B SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS	SCALE

BI 02.08.06 *UPH* CAN BE MADE FROM D3166-1

RELEASED
R 960507



D2235-1



D2235-3

CAN BE MADE FROM D3166-1 *BI*
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.
NO.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

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